

~~PRELIMINARY ISSUE~~

OK to D4133 Rev. A, with deviation (over) 10.09.27

Work Order ID 62156

Monday, September 20, 2010 8:27:11 AM

Page 1

Item ID: D4133-3

Accept

Revision ID:

Item Name: Gasket

Start Date: 9/17/2010 Start Qty: 4.00

Required Date: 9/24/2010 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-9-20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4133

pbl

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4133

Dwg Rev: pbl

Prog Rev: pbl

2-Deburr if necessary

10-9-21

(4)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-9-21

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

- inspected to PB/

Dwg only

8/10/12/22

(74)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.06.27	140	Acceptable to D4133 Rev A. width 5.51 5.61 wider, Dwg = 5.31, PART 2 5.61, acceptable	CP	10.06.27	4	CP 10.06.27 042	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62156

Monday, September 20, 2010 8:27:11 AM

Page 2

Item ID: D4133-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Gasket

Start Date: 9/17/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 9/24/2010 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

RB 10-09-27 *(4)*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/29 *QC21 to Rev. A with deviation per CP.*

mf
10-9-28

POSITIVE RECALL

EFFECTIVE *10.09.17* AUTH *CP*

RELEASED *CP* DATE *10.09.27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, September 20, 2010 8:27:17 AM

Page 1

Work Order ID: 62156



Parent Item: D4133-3



Parent Item Name: Gasket

Start Date: 9/17/2010

Required Date: 9/24/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	477.6133	2.735	11.51579			
NEOPRENE SHEET 0.063													



1810-9-21

Location

Loc Qty

Loc Code

MAT

372.3602

114691

105.9602

115500

266.4

MAT052

105.2531

114176

105.2531

115500

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 62156
Description: GASKET		Part Number: D4133-3
Inspection Dwg: D4133-3 Rev: ph1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

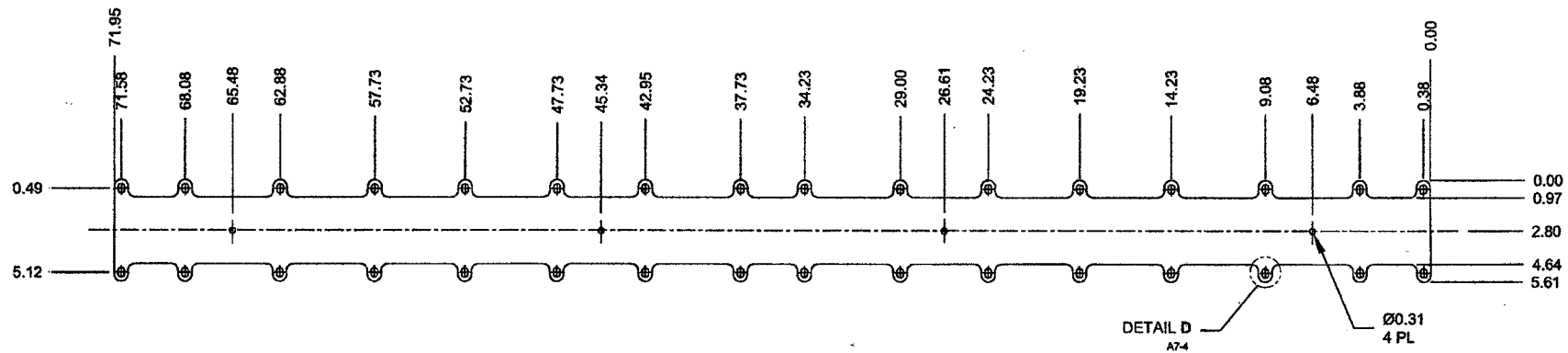
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .31	+ .005 - .001	.311	X	REJECT	V ISO2	
.49	+/- .030	.485	X		V	
.34	+/- .030	.336	X		V	
.49	+/- .030	.480	X		V	
.97	+/- .030	.961	X		V	
2.80	+/- .030	2.771	X		V	
4.64	+/- .030	4.613	X		V	
5.12	+/- .030	5.109	X		V	
5.61	+/- .030	5.605	X		V	
.38	+/- .030	.383	X		V	
3.88	+/- .030	3.860	X		V	
6.48	+/- .030	6.464	X		V	
9.08	+/- .030	9.072	X		V PRO ISO2	
14.23	+/- .030	14.23	X		T ISO1	
19.23	+/- .030	19.23	X		T	
24.23	+/- .030	24.23	X		T	
26.61	+/- .030	26.61	X		T	
29.00	+/- .030	29.00	X		T	
34.23	+/- .030	34.23	X		T	
37.73	+/- .030	37.73	X		T	
42.95	+/- .030	42.95	X		T	
45.34	+/- .030	45.34	X		T	
					T	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-9-21	Date: 10/09/22	Date:	N/A

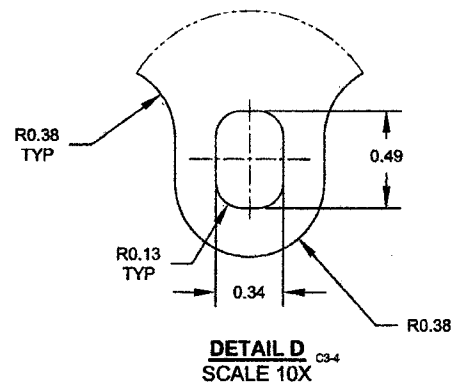
inspect to PBI Day only

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1



D4133-3 GASKET



NOTES:

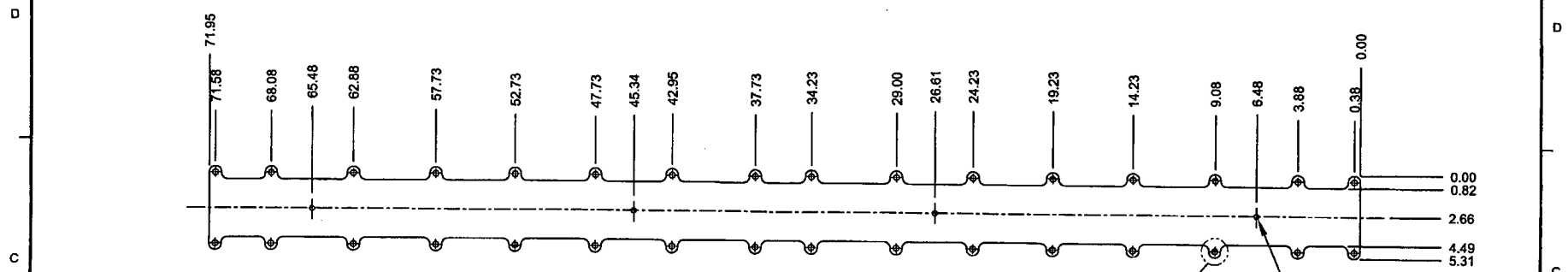
- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER
REF DART SPEC M-NEO60-S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.90 lbs

PRELIMINARY ISSUE

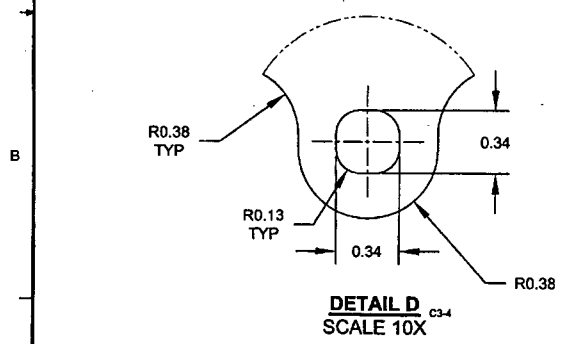
DESIGN	<i>Q</i>	DART AEROSPACE USA, INC	
DRAWN	<i>Q</i>	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. <i>B</i>
MFG. APPR.		D4133	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE, MID	NTS
DATE	10.09.15	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D4133-3 GASKET



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 62156

RELEASED
2010-06-29
M

- NOTES:**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER
REF DART SPEC M-NEO60-S.063
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.90 lbs

DESIGN	??	DART AEROSPACE USA, INC	
DRAWN	??	PORT HADLOCK, WA	
CHECKED	??	DRAWING NO.	REV. A
MFG. APPR.	??	D4133	SHEET 4 OF 4
APPROVED	??	TITLE	SCALE
DE APPR.	??	WEARPLATE, MID	NTS
DATE	10.06.15	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC	

8 7 6 5 4 3 2 1